| Work Order Monday, November | | | | | | | | | | | | Page 1 |
|--|------------------------|--|---------------------------------------|------------------------|---------------------|--------|--------------|---------------|------------------|---------------|------------------|----------------|
| Item ID: D Revisio ID: | 3578-041 | | | Accept | | | | | Setup | | 1 /8871181 | |
| | oubler | | 1 (3 811) 6 6 6 1 | 2 511 (22) | | | | | • | Stop | | 42 |
| Start Date: 11 Required Date: 11 Reference: | 1/22/2010 1/30/2010 | Start Qty: 40.00 Req'd Qty: 40.00 | 1 34434 1 1414 1 14414 1 1414 | 11/1 11/1 11/1 11/1 | Cust Item Customer: | | | | | | | |
| Approvals: P | Process Pla | n: | Date: 10-11- | Tooling: | D | ate: | | | Run | Start | | |
| (| QC: | | Date: | SPC (Y/N): | D | ate: | | | | Stop | | |
| Sequence ID/ Work Center ID | | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | ision Nbr | · · · · · · · · · · · · · · · · · · · | | | | | | | | | |
| D3578 | Rev | A | | | | | | | | | | |
| | | FLOW WATER JET | | 0.00 | | | | \B (c | 7-((<u>-</u> _9 | 4 | | |
| Waterjet FLOW CNC Waterjet 606 -690 | | Memo 1-Cut as per Dwg Rev:_ Prog Rev:_ 2-Deburr if | Δ | 0.00 og. D3578-1) | | | | • | | | \$ | (6) |
| 1100 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 111 - 1 | | QC2- Inspect parts off m | achine FAI/FAIB | 0.00 | | | | | ο. | >6 | i | |
| QC . Quality Control | | Memo | | 0.00 | | | | | <u>-B(0-</u> | 4(~ 5 | (| <u> </u> |
| 120 | | QC8- Inspect parts - seco | ond check | 0.00 | | | | Cou | to | | | |
| | | Мето | | 0.00 کردا | 14/24 | | | (75x | /ע | | | |

Quality Control

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| W/O: | | | WO | RK ORDER CHANGI | ES | | | | |
| DATE | STEP | PRO | OCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Appròval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | jory: | NCR: Yes | No DQ A | ٨: | _ Date: _ | |
| | Res | solution: | Disposition |): | _ QA: N/C Cld | sed: | | Date: _ | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | NCE (NCR |) | | | |
| DATE | STEP | Description of NC | | on B | Verific | ation | Approval | Approval | |
| | J.L. | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section | on C | Chief Eng | QC Inspector |
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Work Order ID 63967

Monday, November 22, 2010 10:30:12 AM



Page 2

Item ID:

D3578-041

Accept



Setup Start



Revision ¹D:

Start Date:

Item Name: Doubler

Required Date: 11/30/2010

Start Oty: 40.00 11/22/2010

Req'd Otv: 40.00



Cust Item ID: Customer:

Tool ID

Reference:

| A | | |
|----|--------|-----|
| Ap | proval | ls: |

Date:

Date: SPC (Y/N):

Tooling:

Date:

Date:

Tool # Plan

Code

Run

Reject

Qty

Stop

Reject

Number

Sequence ID/

Work Center ID

130

Small Fab Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

OC5- Inspect part completeness to step on W/O

Start

Stop

Insp.

Stamp

140

Memo

Memo

0.00

wento

Accept

Otv

Quality Control

Chemical Conversion Coat per OSI005 4.1

8 10 14 170

M 10/11/30 JO_

150

HandFinish

Hand Finishing

Memo

| | - | | | | | | | | |
|---------|------|-------------------|--------------|--|------------|--------------|--------------|-------------------------------|--------------------------|
| W/O: | | | WO | RK ORDER CHANGE | S | | | | |
| DATE | STEP | PRO | OCEDURE CHAP | IGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Categ | jory: | NCR: Yes | No DQ | A: | _ Date: _ | |
| | Res | solution: | Disposition | : | QA: N/C CI | osed: | | Date: _ | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | NCE (NCR | 1) | | | |
| DATE | STEP | Description of NC | Initial | Corrective Action Section Action Description | | | cation | Approval | Approval |
| | | Section A | Chief Eng | Chief Eng | Date | Sect | ion C | Chief Eng | QC Inspector |
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Work Order ID 63967

Monday, November 22, 2010 10:30:12 AM



Page 3

Item ID:

D3578-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Doubler

Start Date: 11/22/2010

Start Otv: 40.00

Required Date: 11/30/2010 Reg'd Qty: 40.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Oty

Start

Sequence ID/

Work Center ID

160

Ouality Control

Operation Description

OC3- Inspect Part Finish

Set Up/ Run Hours

0.00

Run

Stop

Memo

0.00

Tool ID

Tool # Plan

Oty Code

Accept

Reject Reject

Insp. Number Stamp

170

Small Fab

Small Fab

Memo

Small Fab

1-Assemble as per dwg D3578

0.00

0.00

180

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

(auto

| Dart Ae | rospace | Ltd | | | | | | | | |
|---------|---------|-------------------|---------------------------|-----------------------------|---------------|----------------|---------|--------|-------------------------------|--------------------------|
| W/O: | | | WC | RK ORDER CH | ANGES | | | | | |
| DATE | STEP | PRO | OCEDURE CHA | NGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | | | | | | | | |
| | Re | esolution: | Disposition | n: | QA | : N/C Cld | sed: | | Date: _ | |
| NCR: | | | WORK ORDI | ER NON-CONFO | RMANCE | (NCR |) | | | |
| DATE | STEP | Description of NC | Corrective Action Section | | | | Verific | cation | Approval | Approval |
| DATE | SIEP | Section A | Initial Chief-Eng | Action Descrip Chief Eng | otion ———— | Sign & Date | Sect | ion C | Chief Eng | QC Inspector |
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Work Order ID 63967

Monday, November 22, 2010 10:30:12 AM



Page 4

Item ID:

D3578-041

Accept



Setup Start



Revision ID:

Item Name:

Doubler

Start Date: 11/22/2010

Start Qty: 40.00

Required Date: 11/30/2010

Req'd Qty: 40.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop

Stop

Sequence ID/ **Work Center ID**

190

Packaging

Operation **Description**

Identify as per dwg & Stock Location

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/12/01 A

| W/O: | | | WC | RK ORDER CHANGI | ES | | | | h ne |
|---------|------|-------------------|---------------------------------|------------------------------|------------|----------|--------------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | CEDURE CHA | NGE | Ву | D | ate Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Ye | s No | DQA: | Date: | |
| | | esolution: | | | | | | | |
| NCR: | | \ | WORK ORDI | ER NON-CONFORMA | NCE (NO | CR) | | | |
| DATE | CTED | Description of NC | Description of NC Corrective Ac | | on B | | Verification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sig: Da | า & 📗 | Section C | Chief Eng | QC Inspector |
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Picklist Print

Monday, November 22, 2010 10:30:15 AM

Work Order ID: 63967

Parent Item:

D3578-041

Parent .tem Name: Doubler



Start Date: 11/22/20:0

Required Date: 11/30/2010

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A□07.04.11□New issue□EC□

IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Status Issued |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|-----------------------|
| M\$20426AD3-3 | | Purchased | No | | | 110 | Each | 4,011.000 | 2 | 895 re | /11/3 |) (O |
| | | | | Location | ! | Loc | <u>Otv</u> | Loc Code | | | | |
| | | | | ST316 | 19099 | | 4011 4011 | | | 100 | - | |
| M6061T6S.080 | | Purchased | No | | 15055 | 170 | sf | 7.8150 | 0.007 | 0.29473 | 7 ,4 | |
| 6061-T6 .080 Sheet | | Į | | | | | | | | | KB10-1 | ۲۶ - ۱ |
| 0001-10 .000 Sheet | | | | Location | <u>l</u> | Loc | <u>Oty</u> | Loc Code | | | | (50) |
| | | | | MAT | 115600 | | 7.815 | | _ | 11- 1 a.U | , | |
| MS21075L3 | | Purchased | No | | 115689 | 170 | 7.815 Each | 39.0000 | 1 - | 114 684 40 - | + | , |
| | | Turchased | | | | | | 0710000 | | E/S | 0/11/ | 30 |
| Nutplate | | | | Location | <u>1</u> | Loc | <u>Otv</u> | Loc Code | | | | |
| • | | | | ST303 | | | 1 | | | • | - <i>Uli</i> | 11. 142 /29 |
| | | | | ST350 | 113734 | | 1 38 | | _ | | _ //// | 0x 12 (x 1. |
| | | , | | 31330 | 115908 | | 38 38 | | _ | 21 | - | |

| W/O: | | | W | ORK ORDER CHANG | ES | | | • * |
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| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date Qt | y Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR: Yes | No DQA: | Date: _ | |
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| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NCR | 3) | | |
| DATE | CTED | Description of NC | | Corrective Action Secti | | Verification | n Approval | Approval |
| DATE | STEP | Section A | Initial Action Descri Chief Eng Chief Eng | | Sign 8 Date | Section C | Chief Eng | QC Inspector |
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| DART AEROSPACE LTD | Work Order: | 43911 |
|------------------------------|--------------|-------------|
| Description: Doubler | Part Number: | D3578-1 |
| Inspection Dwg: D3578 Rev: A | | Page 1 of 1 |

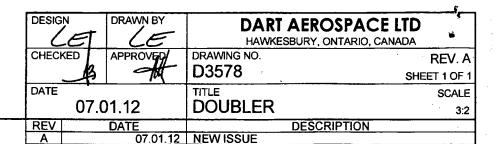
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| Meas | ured by: | IR | Audited by | <u> </u> | | Prototy | ype Appre | | N/A |
| | Date: | 10-11-24 | Date | 10/4/ | 24 | | | Date: | N/A |
| Rev | Date | Change | | | | | Revise | d by | Approved |
| Α | 07.11.23 | New issue | P/O D35 | 78-041 | | | KJ/EC/ | DD 📈 | |

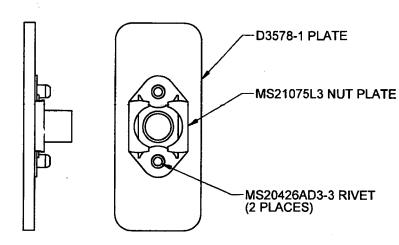
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| W/O: | | | W | ORK ORDER CHAN | IGES | | | |
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| DATE | STEP | PRC | CEDURE CHA | ANGE | Ву | Date (| Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | egory: | NCR: Yes | No DQA : | Date: _ | |
| | R | esolution: | Disposition | on: | QA: N/C CI | osed: | Date: _ | |
| NCR: | | \ | WORK ORD | ER NON-CONFOR | MANCE (NCF | R) | | |
| DATE | STEP | Description of NC Corrective Action | | | Section B | Verificat | | Approval |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | n Sign 8 Date | Section | C Chief Eng | QC Inspector |
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^{*} NOTE: Date & initial all entries







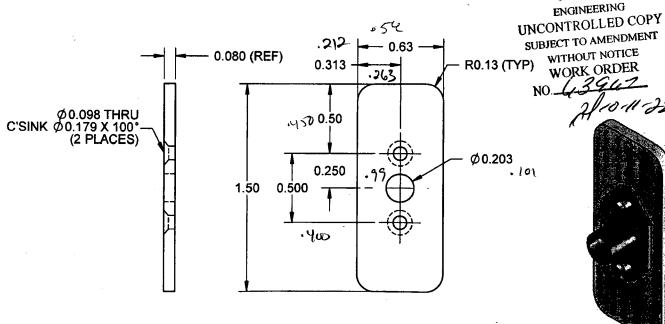
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D3578-041 PARTS LIST:

| QTY | P/N | DESCRIPTION DOUBLER | | | | |
|-----|--------------|---------------------|--|--|--|--|
| Х | D3578-041 | | | | | |
| | | | | | | |
| 1 | D3578-1 | PLATE | | | | |
| 1 | MS21075L3 | NUT PLATE | | | | |
| 2 | MS20426AD3-3 | RIVET | | | | |

D3578-041 DOUBLER

D3578-041 NOTES: 1) IDENTIFY V."TH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER SHOP COPY RETURN TO



D3578-1 PLATE

D3578-1 NOTES

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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| W/O: | • | | W | ORK ORDER CHANG | GES | | · · · · · · · · · | * · | | | |
|-------------|------|--------------------------------|--|-----------------|------|------------------------|-------------------|--------|-------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No: | | PAR #: | Fault Category: | | | NCR: Yes No DQA: Date: | | | | | |
| Resolution: | | | Dispositi | Disposition: | | | osed: | Date: | | | |
| NCR: | | | WORK ORI | DER NON-CONFORM | ANCE | (NCR |) | | | | |
| DATE | STEP | Description of NC Section A | Corrective Action Section Initial Action Description | | | Sign & | | cation | Approval | Approval | |
| | | | Chief Eng | Chief Eng | | Date | Sect | ion C | Chief Eng | QC Inspector | |
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